

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002749**Date Inspected:** 19-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	C.M. Chen,	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	

Bridge No: 34-0006**Component:** Floor Beams, Side Plates , Bottom Plates, Deck**Summary of Items Observed:**

The Quality Assurance (QA) Inspector,Mahlon Lindenmuth,arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following:

QA Inspector, Lindenmuth, observed the work being performed in Bay 2 of the New OBG. ZPMC personnel were performing various functions related to the fabrication of the OBG Side Plates and Bottom Plates as well as the deck sections in the jig fixture. The fabrication performed includes but is not limited to the preparation of areas where temporary welds for strongbacks are located, bevel preparation and welding of the Complete Joint Penetration welds (CJP)on Side Plates and Bottom Plates,heat straightening of Side Plates and Bottom Plates.

Member identification and the work performed on the members are as follows:

North Jig Fixture

QA Lindenmuth observed ZPMC and ABF personnel performing surveying on the North jig fixture. Currently there are no deck segments positioned in the fixture.

South Jig Fixture

Segment 3BE(SEG16) Panel Point 23: QA Lindenmuth observed that no welding has been performed on the segment on the AM shift. Caltrans QA Inspector Alfredo Acuna performing Ultrasonic Testing review of the diagonal tie in connection plates located on the lower flange of Floor Beam 3BE-FL2-1. QA Acuna's findings are have been recorded and filed on PMIV.

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Shop Welding

Segment SEG017A-004 (Side Plate): QA Lindenmuth observed ZPMC Quality Control(QC) personnel performing UT inspection of backgouged and weld repaired areas of the Complete Joint Penetration(CJP) weld joining SP14A to SP15A and SP13A to SP14A. ZPMC QC noted that some repaired areas located on the CJP joining SP13A to SP14A, will require a second time repair.

Segment 017A-005 (Side Plate): QA Lindenmuth observed ZPMC Quality Control(QC) personnel performing UT inspection of backgouged and weld repaired areas of the Complete Joint Penetration(CJP) weld joining SP48 to SP60. ZPMC QC had not finishd the UT inspection during QA Lindenmuth's review of the work area.

General Note: All work observed,unless otherwise noted, appeared to comply with contract documents

Summary of Conversations:

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Lindenmuth,Mahlon	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
